

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009910**Date Inspected:** 28-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Gong Liang Zhu, Chen Ying Xin.			CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No N/A
				Delayed / Cancelled:	Yes	No N/A
Bridge No:	34-0006			Component:	Tower	

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

Bay 10 North Tower Lift 3 corner B/C triangle plate

This QA inspector performed random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. The members are identified as Tower Components. The weld designations reviewed are as follows.

NSTL3-3B/K-18, 20
NSTL3-3C/K-20, 21, 100, 101
NSTL3-3F/K-16, 18, 94
NSTL3-3F/K-93 (VT REJECT, DUE TO IMPROPER WELDING, WELD PROFILE)
NSTL3-3G/K-22, 23, 111, 112
NSTL3-3H/K-16, 17, 92, 93
NSTL3-3I/K-20, 21, 111, 112
NSTL3-3J/K-16, 17

This Quality Assurance (QA) Inspector observed the following work in progress:

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Bay 10

FCAW welding of weld joint 3B located on NSD1-SPSA3-70.

Welder is identified as 040261. ZPMC CWI is identified as Mr. Gong Liang Zhu.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U5-F.

FCAW welding of weld joint 1B located on SSD1-SPSA3-56.

Welder is identified as 040345. ZPMC CWI is identified as Mr. Gong Liang Zhu.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U5-F.

South Tower Lift 4 B/C corner seam

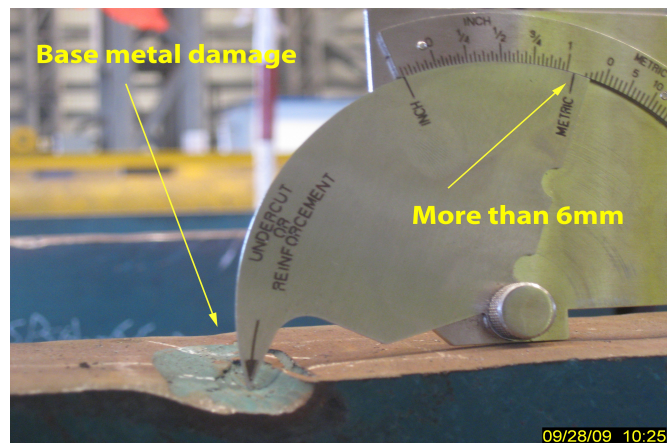
SMAW welding of weld joint 5A located on SSSL4-1B/L.

Welder is identified as 040581. ZPMC CWI is identified as Mr. Wan Wen Zhong.

The welding variables recorded by QC appeared to comply with WPS-B-P-2214-C-U2.

During random verification Visual Testing (VT) of stiffener of north tower interior splice plate, located in the Tower bay 10, Caltrans Quality Assurance (QA) Inspector observed stiffener base metal was damaged at the edge. The stiffener base metal damage was measured as being 50mm in length, 25mm in width and more than 6mm in depth approximately. This damage was caused by gas flame cutting and the stiffener was identified as NSD1-SPSA3-66. This QA inspector prepared an incident for this issue. The attached photographs provide additional detail.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Jim Simonis - 134-7246-3441, who represents the Office of Structural Materials for your project.

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Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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